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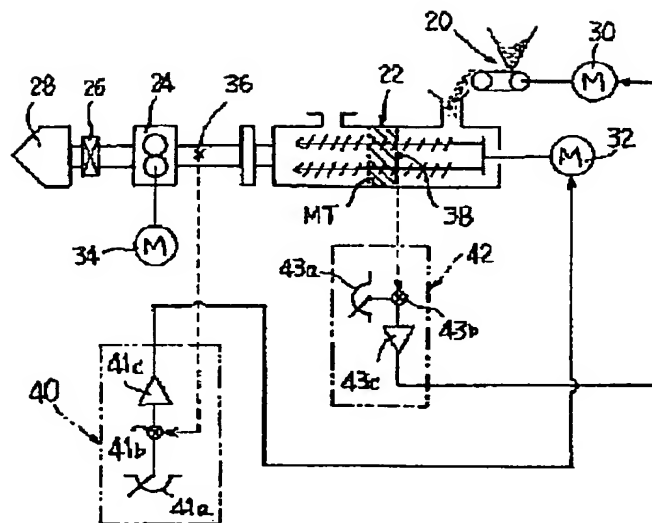
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TITLE : METHOD AND APPARATUS FOR CONTROLLING OPERATION OF TWIN-SCREW EXTRUDER



ABSTRACT : PROBLEM TO BE SOLVED: To successfully achieve the stable control of a twin-screw extruder at the times of rising, falling and emitting amount alteration in an extrusion molding apparatus for molding a resin sheet or film by using the twin-screw extruder and a gear pump.

SOLUTION: In this control method, the resin raw material sent out of a raw material supply machine 20 is supplied to a twin-screw extruder 22 and kneaded and melted to be extruded and the molten resin extruded from the twin-screw extruder is quantitatively emitted through a gear pump 24 to be molded into a sheet or film. At a time of molding when the speed of the gear pump reaches a set speed, the speed of the twin-screw extruder 22 is subjected to feedback control so that the front pressure P1 of the gear pump becomes set pressure and the speed of the raw material supply machine 20 is subjected to feedback control so that the front pressure P2 of the melt part in the twin-screw extruder becomes set pressure.

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